



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-3
Job Sheet 171504



Part No: D4776-3

Job Qty: 30 ea

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/2/18

Job Tracking No:

Due Date: 2/12/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D SHEET 2 IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		2/9/18	0.00	0.00	Start Up Machining-3		FK 18-2-7
100	Bandsaw	30 pcs		2/9/18	0.00	0.54	Bandsaw1		FK 18-2-7
110	CNC Vertical Machining	30 pcs		2/10/18	0.26	26.09	HAAS1-5		VK8 FK 18-2-10
120	QC	30 pcs		2/10/18	0.00	0.00	QC2 Machining-3		VK8 F.E 18-2-10
130	QC	30 pcs		2/10/18	0.00	0.00	QC8 Machining-3		mmml 18/02/12
140	HandFinish	30 pcs		2/10/18	0.00	0.79	HandFinish1		2018/02/13 JSK
150	QC	30 pcs		2/10/18	0.00	0.00	QC7-4		BR 18-2-13
160	Powdercoat	30 pcs		2/12/18	0.00	0.37	Powdercoat1		BR 18-2-13
170	QC	30 pcs		2/12/18	0.00	0.00	QC3		38
180	Packaging	30 pcs		2/12/18	0.00	0.00	Packaging3-2	115 SV	9-00
190	QC21-SA	30 Ea		2/12/18	0.00	0.00	QC21		FEB 14 2018

Part Op 100 - Cut Blank at 4.400"

Descriptions: 110 - 1-Machine per folio FB168

160 - START TIME: 1:30 OV.T: 320° FINISH: 2:00. M138467.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.500X01.500	6061-T6 Bar 2.50 X 1.50	11.0100 ft (.367 ea)	90-Start up Operation	S040181

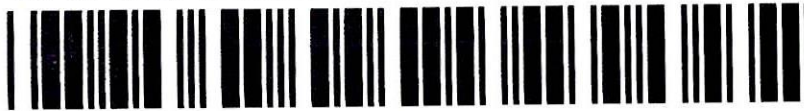
S033410 x 11.17'

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.500X01.500	11	24	0



S040182



Skidtube Clevis

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO: D4776-3

Original Serial #: S040182

Revision:

Operation: Start up Operation 02/07/18

Change No:

Job No: 171504

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.250Inches $\pm$ 0.030	4.280 4.220	4.250	
2	Skidtube Clevis	2.250Inches $\pm$ 0.030	2.280 2.220	2.250	
3	Skidtube Clevis	1.688Inches $\pm$ 0.010	1.698 1.678	1.685	
4	Skidtube Clevis	0.880Inches $\pm$ 0.030	0.910 0.850	.877	
5	Skidtube Clevis	0.510Inches $\pm$ 0.010 + 0.010 - 0.000	0.520 0.510	.515	
6	Skidtube Clevis	1.063Inches $\pm$ 0.010	1.073 1.053	1.062	
7	Skidtube Clevis	1.380Inches $\pm$ 0.030	1.410 1.350	1.375	
8	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	.188	
9	Skidtube Clevis	1.000Inches $\pm$ 0.030	1.030 0.970	.949	
10	Skidtube Clevis	0.484Inches $\pm$ 0.006 + 0.006 - 0.001	0.490 0.483	Diameter .487	
11	Skidtube Clevis	0.500Inches $\pm$ 0.030	0.530 0.470	.500	
12	Skidtube Clevis	0.550Inches $\pm$ 0.030	0.580 0.520	548 548	
13	Skidtube Clevis	3.150Inches $\pm$ 0.010	3.160 3.140	3.150	
14	Skidtube Clevis	1.130Inches $\pm$ 0.030	1.160 1.100	1.130	
15	Skidtube Clevis	0.688Inches $\pm$ 0.010	0.698 0.678	.691	
16	Skidtube Clevis	0.397Inches $\pm$ 0.006 + 0.006 - 0.001	0.403 0.396	Diameter .397	
17	Skidtube Clevis	1.813Inches $\pm$ 0.010	1.823 1.803	1.812	
18	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	Radius .188	
19	Skidtube Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius .125	
20	Skidtube Clevis	0.440Inches $\pm$ 0.030	0.470 0.410	Radius .440	
21	Skidtube Clevis	0.125Inches $\pm$ 0.010	0.135 0.115	.124	
22	Skidtube Clevis	0.380Inches $\pm$ 0.030	0.410 0.350	.350	
23	Skidtube Clevis	0.750Inches $\pm$ 0.030	0.780 0.720	.750	
24	Skidtube Clevis	0.250Inches $\pm$ 0.030	0.280 0.220	Radius 0.250	

Plex 2/2/18 7:50 AM dart.lacelle.linda